Work Or	der ID 58039	
	il 22, 2010 10:28:18 AM	
Item ID:	D4021-7	
Revision ID:		
Item Name:	Ноор	



Page 1

			· ·		4							
tem ID:	D4021-7		•	Accept					Setup	Start		
Revision ID: Item Name:	Ноор				1		*			Stop		
Start Date: Required Date: Reference:	4/22/2010 : 4/23/2010	Start Qty: 10.00 Req'd Qty: 10.00		= 11 (A=)	Cust Item II Customer:	D:						
Approvals:			Date: 10-4-		Da	nte:		]	Run	Start		
			Date:		Da	ıte:				Stop		
Sequence ID/ Work Center I	D	Operation Description	機能のような	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D4021	В						<b>W</b>	الم الم	pul	LE or		
100 Harish Herik Berri Berr (1886)				0.00								<del></del>
Waterjet		Memo	1	0.00				_HB_10	7-H=	<b>)</b> 6_		
FLOW CNC Water	jet	Cut as per Prog Rev: Dwg Rev:	dwg D4021									
		Deburr as				,					(10)	
110		QC2- Inspect parts off	machine FAI/FAIB	0.00							<u> </u>	
QC Quality Control		Memo		0.00				_B(0-	4-76	<b>3</b>		

Dart Ae	rospace	<b>Ltd</b>		·						t v
W/O:			WO	RK ORDER CHANG	ES			,		
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
		•								
Part No	) <b>:</b>	PAR #:	Fault Categ	ory:	_ NCR: Ye	s N	o <b>DQ</b> /	<b>4</b> :	Date: _	<u> </u>
	Re	esolution:	Disposition	:	_ QA: N/C	Clos	sed:		Date: _	
NCR:		·V	VORK ORDE	R NON-CONFORMA	NCE (NC	R)		·		***.
DATE	OTED	Description of NC	Corrective Action Section			Vorifi		ication Approval	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da		Secti		Chief Eng	QC Inspect
					;					
										<u>:</u>

## Work Order ID 58039

Thursday, April 22, 2010 10:28:18 AM



Page 2

Item ID:

D4021-7

Accept



Setup Start

Stop



Revision ID:

Item Name:

Hoop

Start Date: Required Date: 4/23/2010

4/22/2010

**Start Oty: 10.00** 

Rea'd Otv: 10.00



**Cust Item ID:** 

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_ Date:

QC: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Sequence ID/ Work Center ID

120

**Ouality Control** 

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 

Number

Draw

Draw Rev.

Plan Accept Otv Code

Reject Qty

Reject Number Stamp

Insp.

Small Fab Small Fab

130

Memo

1- make radius as per dwg

QC5- Inspect part completeness to step on W/O

2- deburr

0.00

0.00

SY 10/04/26

140

Quality Control

Memo

0.00

Dart Ae	rospace	Ltd								\$ 1 4
W/O:			WC	RK ORDER CH	ANGES					
DATE	STEP	PROCEDURE CHANGE By					Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
									·	
Part No		PAR #:								
NCR:		······································		R NON-CONFO					Date:	
	T	Description of NC		Corrective Action	Section B		Verifica	otion	<b>A</b>	
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	otion	Sign & Date	Sectio		Approval Chief Eng	Approva QC Inspect
- - -										
				7 T T T T T T T T T T T T T T T T T T T						
				-				:		

#### Work Order ID 58039

Thursday, April 22, 2010 10:28:18 AM



Page 3

Item ID:

D4021-7

Accept



Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name:

Hoop

**Required Date: 4/23/2010** 

4/22/2010

**Start Oty: 10.00** 

Req'd Oty: 10.00



Date:

**Cust Item ID:** Customer:

Reference:

А	nı	r	nv	ลเ	S:

Process Plan:

OC:

Date:

Tooling:

SPC (Y/N):

Draw

Number

Date: Date:

Draw

Rev.

Plan

Code

Run

Accept

Qty

Start

Reject

Stop

Number Stamp

Insp.

Sequence ID/ Work Center ID

150

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Set Up/ **Run Hours** 

0.00

0.00

Otv

Reject

160

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/28 98) BS10-4-27

## **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES** Approval **Approval** DATE **STEP** PROCEDURE CHANGE Bv Qtv Chief Eng / Prod Mgr Date QC Inspector Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_ Date: \_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification Approval Approval DATE STEP Initial **Action Description** Sign & Section A Section C Chief Ena QC Inspector Chief Eng Date Chief Eng

### **Picklist Print**

Thursday, April 22, 2010 10:28:17 AM

Work Order ID: 58039

Parent Item: D4021-7

Parent Item Name: Hoop

IPP RevA: new issue DD 09.11.25 verified by:EC Comments:

per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB

DD 10.04.20 verified by:EC

Start Date: 4/22/2010

**Start Oty: 10.00** 

**Required Date: 4/23/2010** 

Required Oty: 10.00

B10-4-26

Component Item ID/ M304B0.625X3.000

Replacement Mfg/

Purchased

Bin Primary No

Last

Route 100

IPP Rev:B as

Unit of f

Oty on

Remaining 15.9000 4.385

Qty

Date

Status

-	
304 BAR .625 X 3.00	

Warehouse Location	Loc Qty	Loc Code	(10)
Main Warehouse			
MAT53	15.9		- 17/55
112320	13.1		27/5.1 = EX OCEGII
112442	2.8		112442 X 7 = 3.0697

Dart Ae	rospace	e Ltd						N <sup>®</sup> ↓ U Got • ↓
W/O:			WC	ORK ORDER CHANG	ES			
DATE	STEP	PR	PROCEDURE CHANGE By					Approva QC Inspecto
		· .						
		•						
Part No	):	PAR #:	Fault Cate	gory:	NCR: Ye	s No DQA:_	Date: _	
	R	esolution:	Disposition	n:	_ QA: N/C	Closed:	Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NC	R)	·	
_		Description of NC		Corrective Action Section	on B	Manisia aki		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da			Approval QC Inspecto
	ļ							

DART AEROSPACE LTD		Work Order:	58031
Description: Hoop		Part Number:	D4021-7
Inspection Dwg: D4021 Rev: A	· ·		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Comments

	X	First Artic	le _	Proto	type
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o
Ø0.194	+0.005/-0.001	.193	\ <u>\</u>		

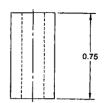
Dimension		Dimension		mspection	
Ø0.194	+0.005/-0.001	.193	<b>&gt;</b>		
0.63	+0.000/-0.005	. 637	<i>y</i>		
1.38	+/-0.030	1.355	15	<u> </u>	
2.25	+/-0.030	2.748	٧		
5.00	+/-0.030	5,00	8		
0.813	+/-0.010	.812	7		
2.500	+/-0.010	4.990	75		
2.56	+/-0.030	2.568	7		
0.625	+/-0.010	862)	8		
					·
·					

		<del></del>	L		
Measured by:	R	Audited by:	-	Prototype Approval:	N/A
Date:	10-4-26	Date: (0	04/2/g	Date:	N/A
		J L	.,		

Rev	Date	Change	Revised by	Approved
Α	10.04.01	New Issue	KJ XX	

5.00 R0.50 4 PL R0.10 2 PL 0.63<sup>+0.00</sup> -0.05 0.813 R1.125 REF 2.56 RFF Ø0.194 TYP R1.438 R1.75 2.500 **D4021-7 HOOP** 

Ø0.191 -- Ø0.38



**D4021-9 BUSHING** 

¥58039

mp

DESIGN	AJS	DART AEROSPACE	ITD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA				
CHECKED	W	DRAWING NO.	REV B			
MFG. APPR.	W	<sup>↑</sup> D4021	SHEET 3 OF 3			
APPROVED	INP.	TITLE	SCALE			
DE APPR.	4	MISC PARTS - 350 BASKET	NTS			
DATE 10.0	4.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOSSABLY IS PRIVATE AND COMPENDATION AND TO EXPORT DO THIS DOTAGE CONTROL THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COMPENDATION TO ANY OTHER PERSON WITHOUT WATTEN PERSONNELL THE REPORT AND THE TOTAGE OF THE PERSON WITHOUT				

NOTES: 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

8 .

Dart	Aerospace L	td
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W/O:		WORK ORDER CHANGES				,		· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PROCEDURE CHANGE B		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	ţ								
								•	
144									
		•							
			7						
Part No:		PAR #:	Fault Cat	egory:	NCR: Ye	s No <b>DQ</b>	<b>A</b> :	Date: _	
	R	esolution:						Date: _	
NCR:		V	ORK ORI	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Action Description		on B Sign	. 0	cation	Approval	Approval
			Chief Eng	Chief Eng	Dat		Section C	Chief Eng	QC Inspector
							·		
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1									
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